

Date: Thursday, 13/11/2008 8:20:42 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	WEARSHOE
Job Number	43406			
Estimate Number	12740			
P.O. Number			Part Number	D353523
This Issue	13/11/2008	S.O. No. :	Drawing Number	D3535 REV B
Prsht Rev.	NC		Project Number	N/A
First Issue	/ /	Type : SMALL /MED FAB	Drawing Revision	B
Previous Run	39134		Material	:
Written By			Due Date	28/11/2008
Checked & Approved By			Qty:	10
Comment	Est Rev:A	New Issue 07-02-15 JLM	Um:	Each
	Est Rev:B	As per Rev B 07-08-31 JLM	Verified By:	EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		 Comment: Qty.: 1.4296 sf(s)/Unit Total : 14.2958 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: 109088 BB 8-11-18
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: B BB 8-11-18 Prog Rev: B
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE BB 8-11-18
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK S 08/11/18 103
5.0	BRAKE NC	NC BRAKE
		 Comment: NC BRAKE 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-23 SB 08/11/24 103 EF 08/11/24 103

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 8:20:42 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 43406

Part Number: D353523

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5: INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sos (11/24) (413)

7.0 POWDER COATING POWDER COATING



M109 648



(13X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 11-30

OVEN TEMPERATURE: 320°

FINISH TIME: 12-00

M-1 08/11/24

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



96



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-24 (X15)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



(13X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-21

M-1 08/11/24

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/11/26 (X)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-24

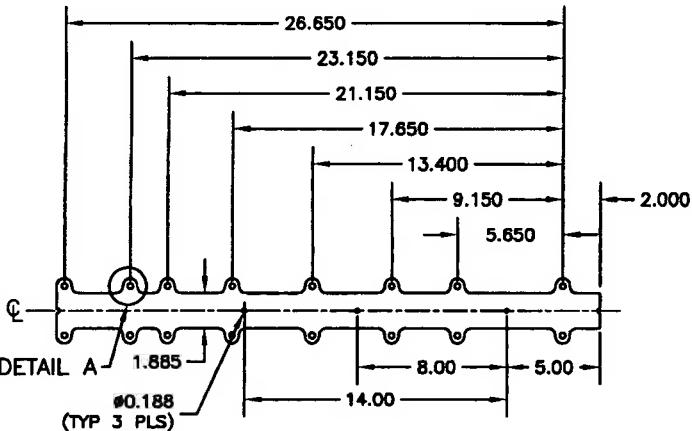
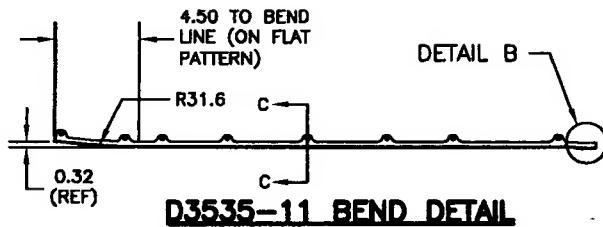
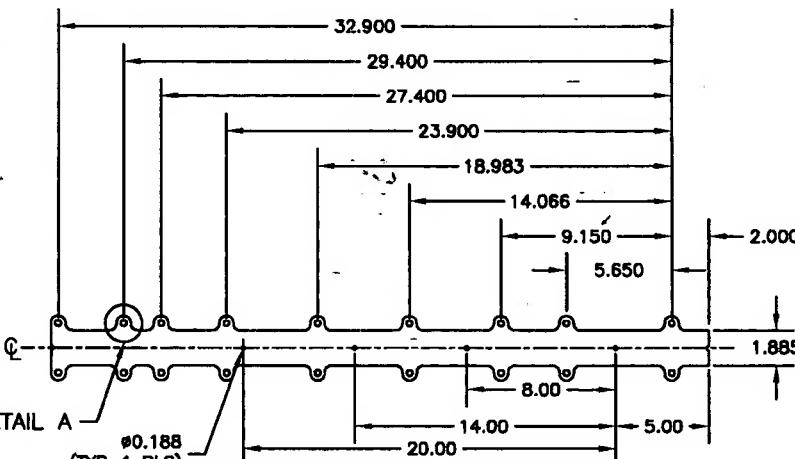
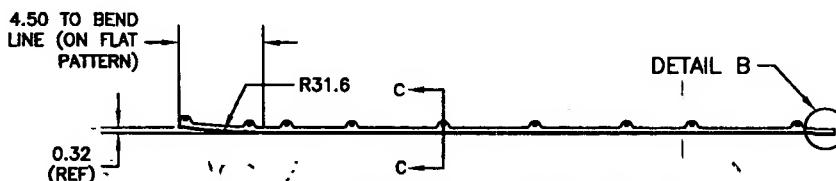
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

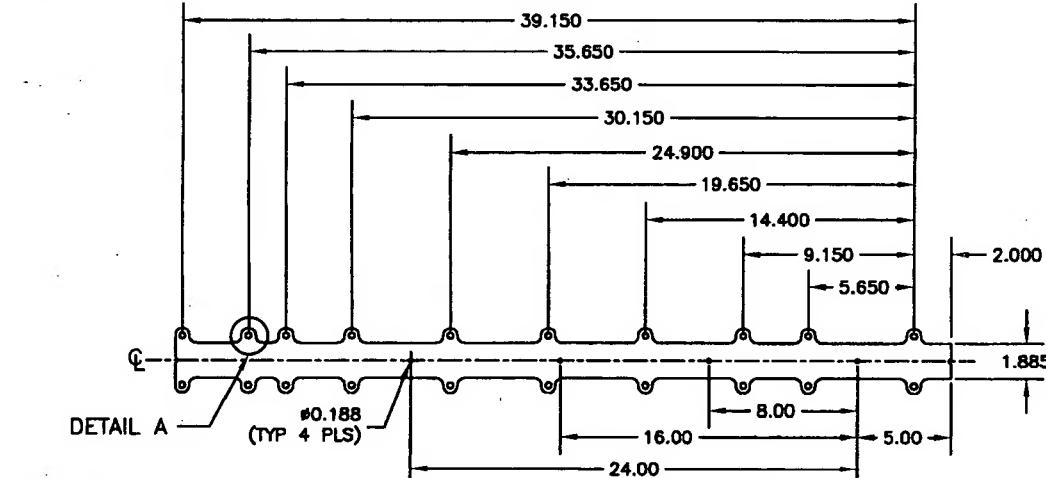
NOTE: Date & initial all entries

DART**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

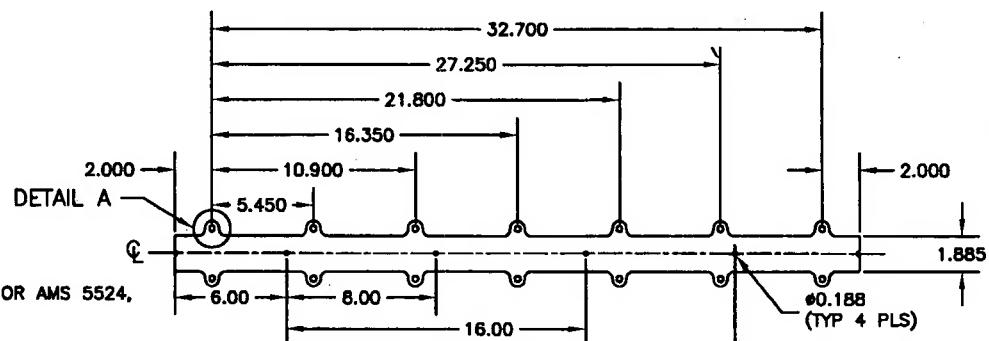
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Copyright © 2006 by DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C B	#	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
#	#	D3535
DATE		SCALE
07.04.17		1:10
A	06.10.25	TITLE
B	07.04.17	WEARSHOE
		REV. B
		SHEET 1 OF 7
		SCALED

DARTRELEASED
07.04.17**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

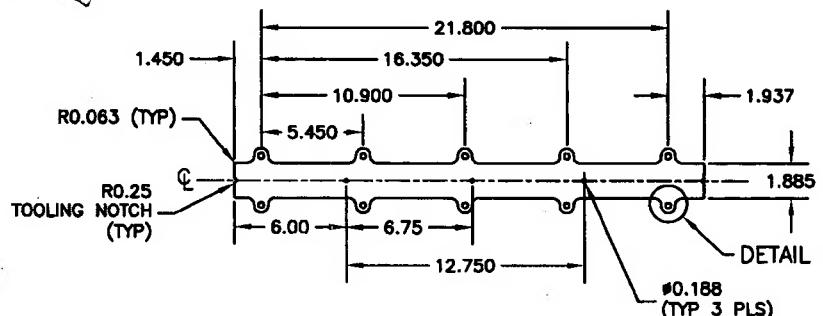
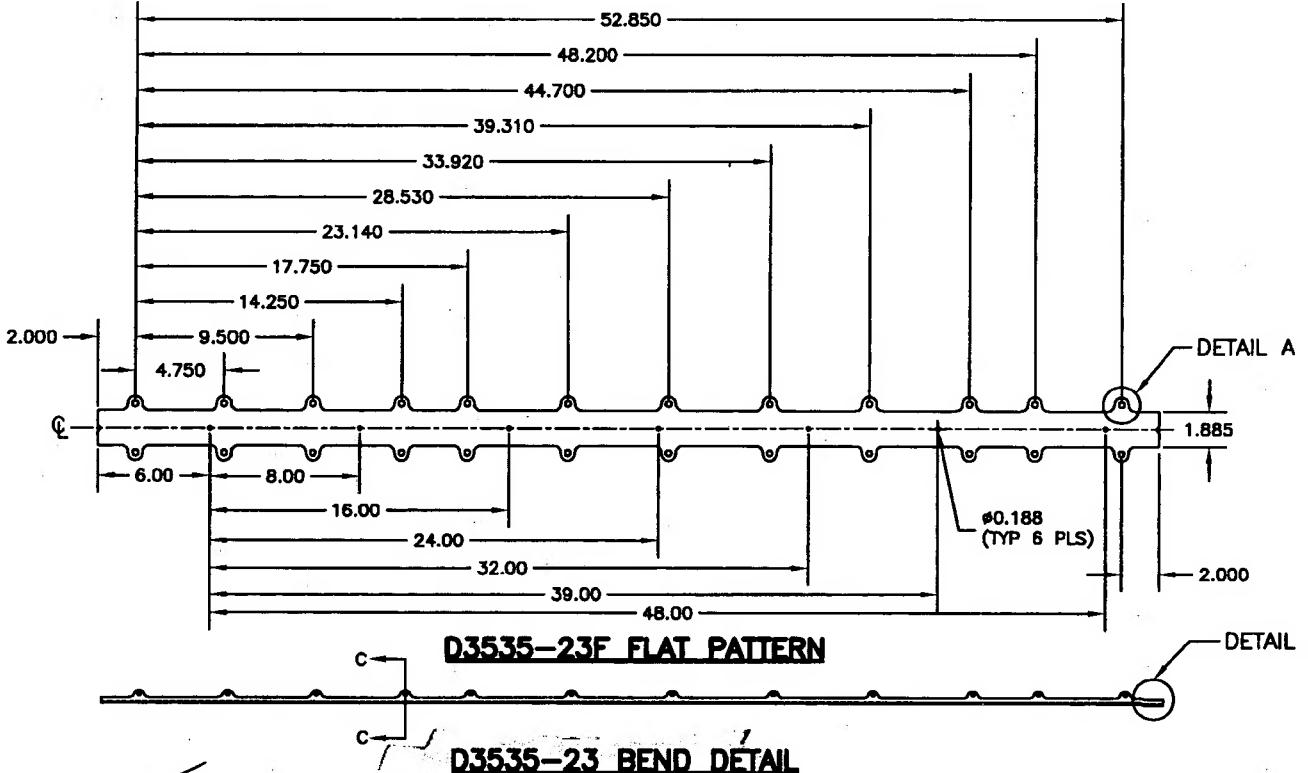
**D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	MM	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
MM	MM	D3535
DATE		SCALE
07.04.17		1:10

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
H	H	D3535
DATE		TITLE
07.04.17		WEARSHOE
		SCALE
		1:10

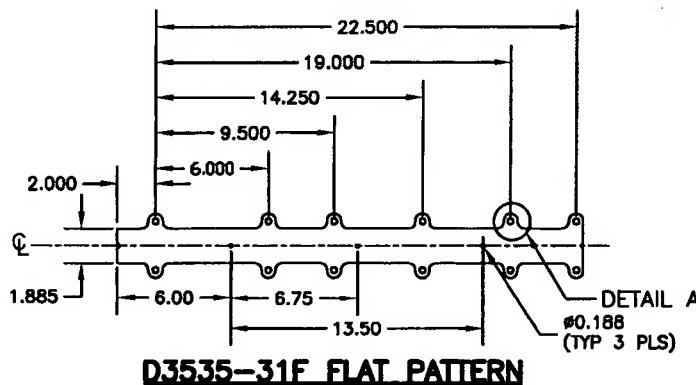
RELEASED
07.04.24

**NOTES**

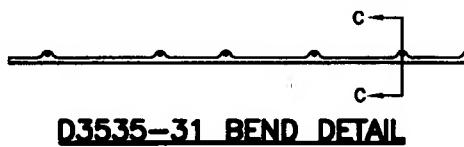
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

RELEASED
07.04.17



D3535-31F FLAT PATTERN



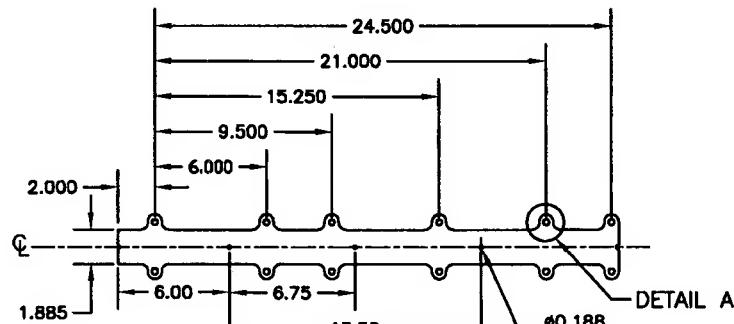
D3535-31 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Copyright © 2006 by DART AEROSPACE USA, INC.



D3535-33F FLAT PATTERN

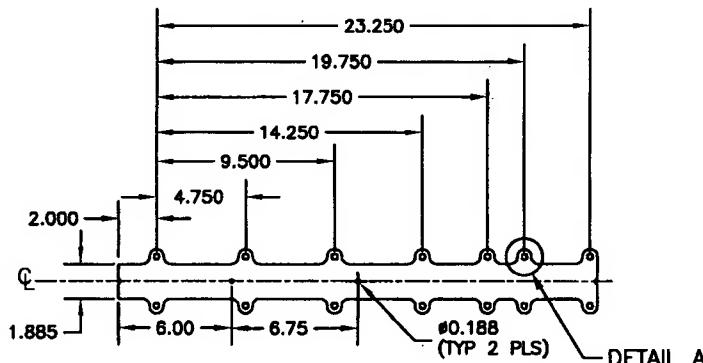


D3535-33 BEND DETAIL

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	PF	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
MF	MF	D3535
DATE		SCALE
07.04.17		1:10
		REV. B
		SHEET 4 OF 7



RELEASED
07.04.17



D3535-35F FLAT PATTERN



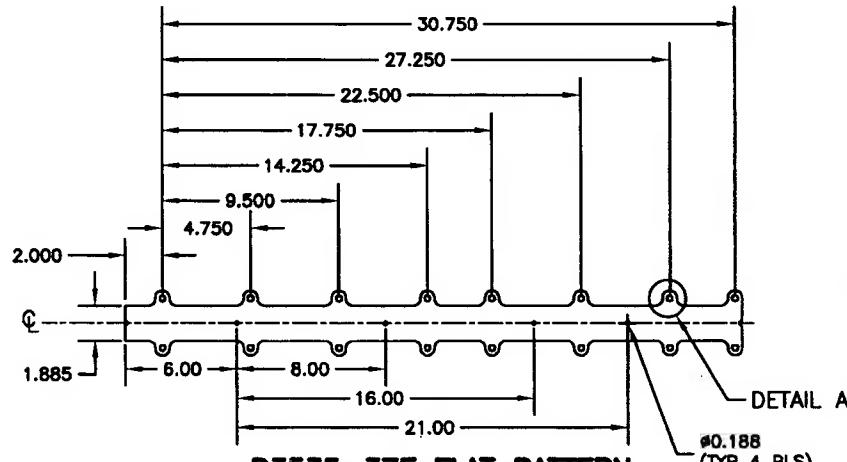
D3535-35 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \mathcal{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Copyright © 2006 by DART AEROSPACE USA, INC.



D3535-37F FLAT PATTERN



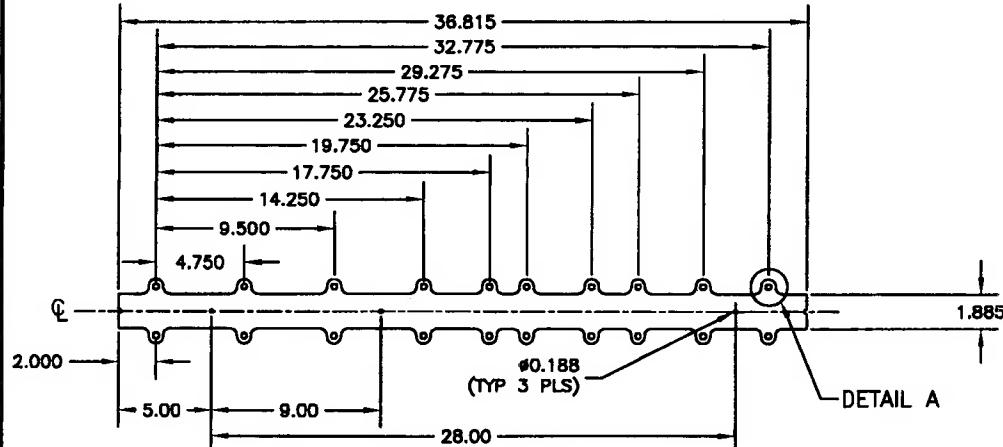
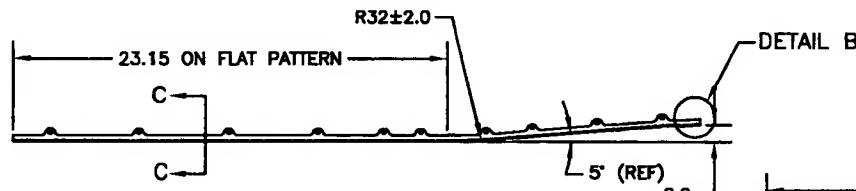
D3535-37 BEND DETAIL

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
C8	PR	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 5 OF 7
W	W	D3535	
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10

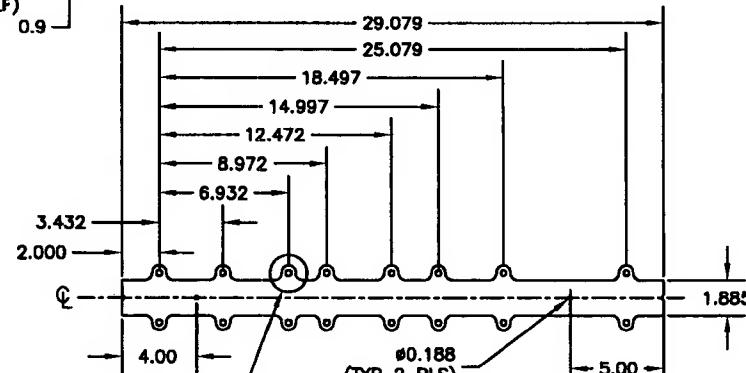
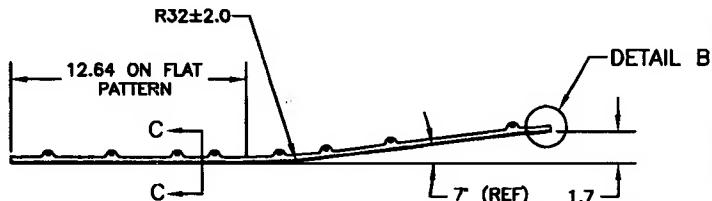
DART

RELEASED

07.04.24

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****NOTES**

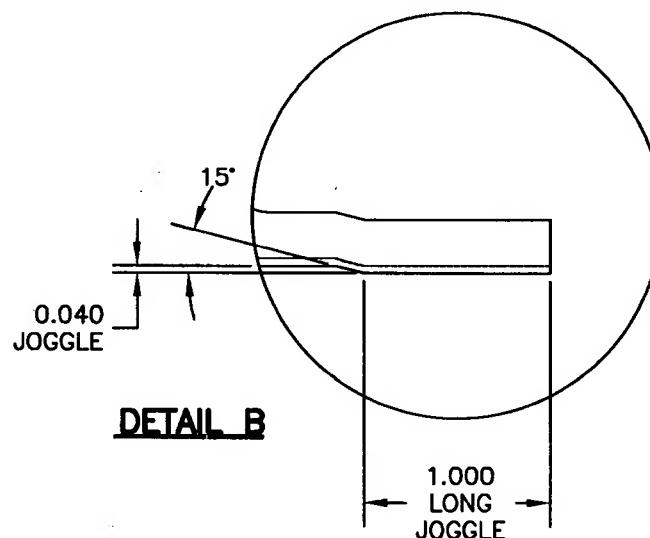
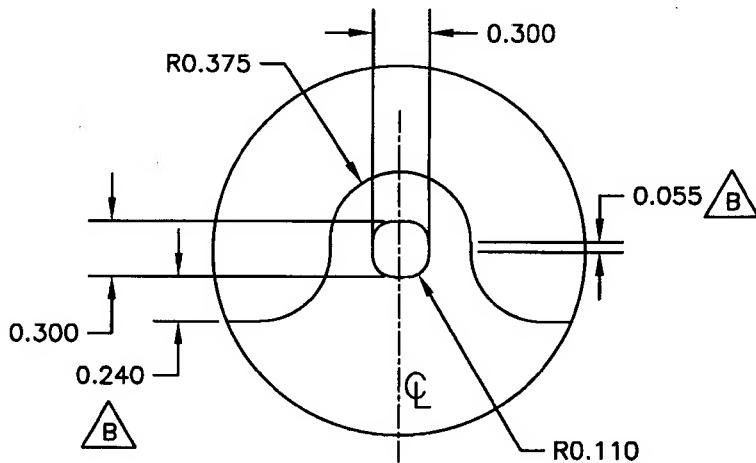
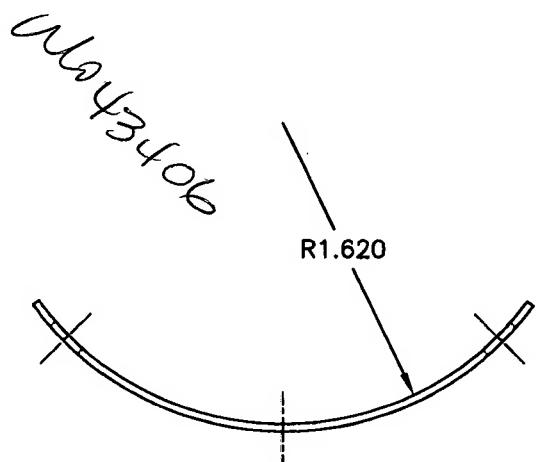
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	M	PORT HADLOCK, WA
CHECKED	W	APPROVED
DATE	W	DRAWING NO.
07.04.17		D3535
		TITLE
		WEARSHOE
		SCALE
		1:10
		REV. B
		SHEET 6 OF 7
		1:10

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	SH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE		REV. B
07.04.17		SHEET 7 OF 7
		SCALE
		1:1

RELEASED
07.04.24 *[Signature]***DETAIL A****SECTION C-C**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Copyright © 2006 by DART AEROSPACE USA, INC.

DART AEROSPACE LTD

Work Order: 43406

Description: WEAR SHOE

Part Number: D3535-23

Inspection Dwg: DB535-23 Rev: B

DART AEROSPACE LTD	Work Order:	43406
Description:	Part Number:	D3535-23
WEAR SLEEVE		
Inspection Dwg: D3535-23 Rev: B		Page 1 of 1

ERST ARTICLE INSPECTION CHECKLIST

First Article	X	Prototype
---------------	---	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 188	+ .005 - .001	190	X			
300 X 300	+/- .010	302 X 303	X			
1.885	+/- .010	1.888	X			
2.020	+/- .010	2.000	X			
2.000	+/- .010	2.000	X			
6.00	+/- .030	6.00	X			
8.00	+/- .030	9.00	X			
16.00	+/- .030	16.00	X			
24.00	+/- .030	24.00	X			
32.00	+/- .030	32.00	X			
39.00	+/- .030	39.00	X			
48.00	+/- .030	48.00	X			
4.750	+/- .010	4.751	X			
9.500	+/- .010	9.503	X			
14.350	+/- .010	14.350	X			
17.750	+/- .010	17.750	X			
23.140	+/- .010	23.140	X			
28.530	+/- .010	28.530	X			
33.920	+/- .010	33.920	X			
39.310	+/- .010	39.310	X			
44.700	+/- .010	44.700	X			
48.200	+/- .010	48.200	X			
52.850	+/- .010	52.850	X			

Measured by: BS Date: 8-11-18

Audited by:	<u>S</u>
Date:	06/04/16

Prototype Approval:	<u> </u>
Date:	1/1/01

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	

INFORMATION SECURITY: A SURVEY OF CURRENT TRENDS